

Work Order ID 134835

Tuesday, July 21, 2015 2:45:31 PM

134835

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Item ID: D2654-5

Accept

N900040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Web

Start Date: 7/21/2015 Start Qty: 4.00

4

Cust Item ID:

Required Date: 7/21/2015 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: MLJ Date: JUL 21 2015 Tooling: _____

Date: _____

Run Start

NR1

QC: _____ Date: _____ SPC (Y/N): _____

Date: _____

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr	Revision Nbr
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D2654	F
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100

0.00

100

Skidtubes

Skidtubes

Memo

0.00

Skidtubes

1-Cut D2600-7 to length as per Dwg D2654
2-Drill pilot holes in web using drill jig DT 8018-5 as per Dwg D2654
3-Using the uni-bit, open holes to finish size as per Dwg D2654
4-Deburr holes and ends

4 15-7-27 DGC

DAS
18
9-00

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

4 15-07-27

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

4 15-7-29

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Item ID: D2654-5 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Web
Start Date: 7/21/2015 Start Qty: 4.00 ***4*** Cust Item ID:
Required Date: 7/21/2015 Req'd Qty: 4.00 ***4*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	QC7-Inspect Chemical Conversion Coat	0.00				4	0	15-7-29	GL
130									
QC	Memo	0.00							
Quality Control									
140	Identify as per dwg & Stock Location <u>LG002</u>	0.00				4	0	15-7-29	GL
140									
Packaging	Memo	0.00							
Packaging	LOCATION : LG002								
150	QC21- Final Inspection - Work Order Release	0.00						15/7/29	GL
150									
QC	Memo	0.00							
Quality Control									

Su 0150729

Picklist Print

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Work Order ID: 134835

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Parent Item: D2654-5

D2654-5

Parent Item Name: Web

Start Date: 7/21/2015

Required Date: 7/21/2015

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:D 99.02.04 Fixed typo, Changed procedureDM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2600-7-140		Manufactured	No			100	Each	67.0000	1	4			

D2600-7-140

EXT. "I BEAM" THICK

Location

Loc Qty

Loc Code

LG

67

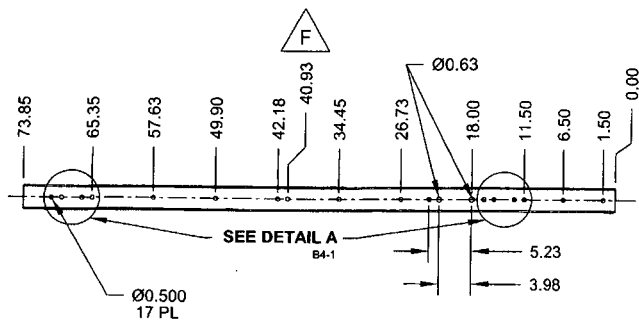
67

131525

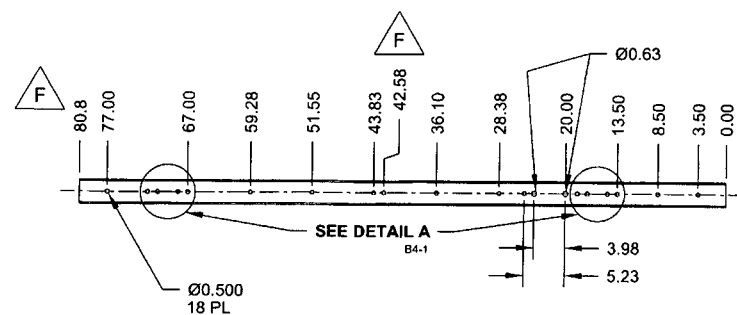
AD

DGC

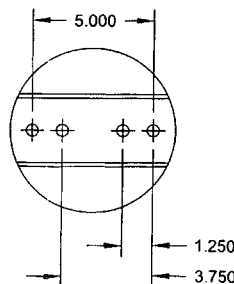
15-7-27-



D2654-1 WEB



D2654-3 WEB



DETAIL A

C2-1
C3-1
C6-1
C8-1
D3-2
D6-2
B3-2
B6-2

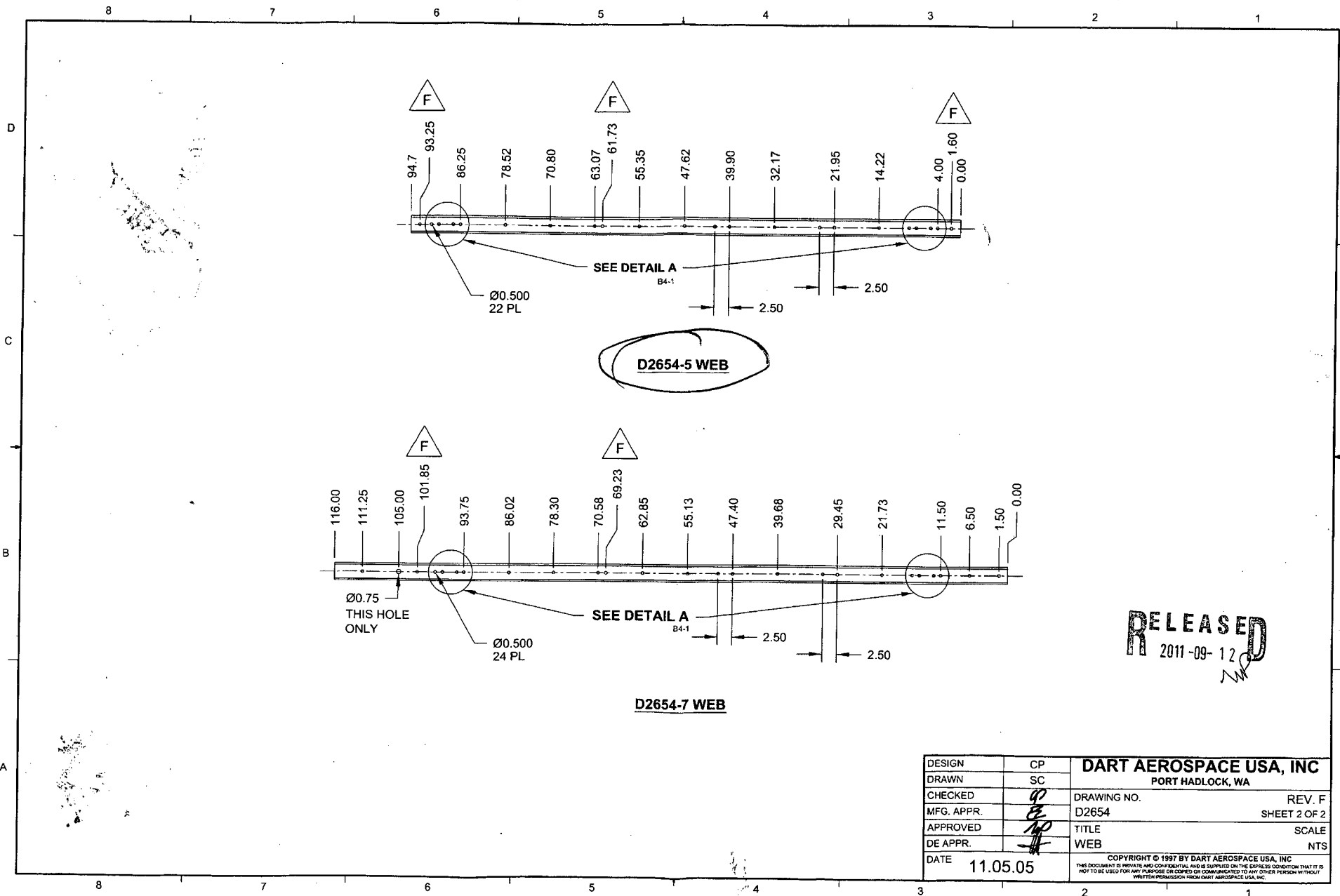
NOTES:

- 1) MAKE D2654-1/-3 FROM D2600-5-108 EXTRUSION, MAKE D2654-5/-7 FROM D2600-7-125 EXTRUSION
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH P/N "D2654-X" PER QSI 044 6.1 (FINE POINT PERMANENT INK MARKER)
- 7) WEIGHT: D2654-1 = 2.2 lbs; D2654-3 = 2.4 lbs
D2654-5 = 4.8 lbs; D2654-7 = 5.8 lbs

134835 MJS
15-07-21

RELEASED
2011-09-12

REV.	DESCRIPTION	BY	DATE
F	ADDED ADDITIONAL HOLES ON -5/-7, 80.8 WAS 80.5, INCORPORATED DEO D2654-E-2	SC	11.05.05
E	CHANGE LENGTHS, REFORMAT	CP	04.05.26
D	GHV HOLES CHANGED TO Ø0.63	CP	98.01.15
C	CHANGED HOLE PATTERN	CP	97.10.29
B	ALTER HOLE PATTERN, 0.500 WAS 0.438	CP	97.06.26
A	NEW ISSUE	CP	97.03.25
DESIGN	CP	DART AEROSPACE USA, INC PORT HADLOCK, WA	
DRAWN	SC		
CHECKED	9	DRAWING NO.	REV. F
MFG. APPR.	9	D2654	SHEET 1 OF 2
APPROVED	9	TITLE	SCALE
DE APPR.	9	WEB	NTS
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2011-09-12

DESIGN	CP	DART AEROSPACE USA, INC	
DRAWN	SC	PORT HADLOCK, WA	
CHECKED	<i>GP</i>	DRAWING NO.	REV. F
MFG. APPR.	<i>EE</i>	D2654	SHEET 2 OF 2
APPROVED	<i>JP</i>	TITLE	SCALE
DE APPR.	<i>JP</i>	WEB	NTS
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